

**\*84086\***

Wednesday, May 02, 2012 1:08:54 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 5/2/2012      **Start Qty:** 4.00

**\*4\***

**Customer:**

**Required Date:** 5/8/2012      **Req'd Qty:** 4.00

**\*4\***

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_

Date: 12-05-2 Tooling:

Date:

Stop \*NR2\*

**QC:**

**Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_

**Date:**[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Page 2

Wednesday, May 02, 2012 1:08:54 PM

**Reference:**

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84086

\*84086\*

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Wednesday, May 02, 2012 1:08:54 PM

Item ID: D2207-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Housing Weldment  
 Start Date: 5/2/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 5/8/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*160*									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 7:30	0.00							
	FINISH TIME: 8:00								
	320°F								
170	QC3- Inspect Part Finish	0.00							
*170*									
QC									
Quality Control	Memo								
180	Large Fab	0.00							
*180*									
Large Fab									
Large Fab	Memo								
	Install AK57-1032-130 as per Dwg D2207								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84086****\*84086\***

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Wednesday, May 02, 2012 1:08:54 PM

Item ID: D2207-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Housing Weldment  
Start Date: 5/2/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 5/8/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 02, 2012 1:08:58 PM

Page 1

Work Order ID: 84086

\*84086\*

Parent Item: D2207-041

\*D2207-041\*

Parent Item Name: Housing Weldment

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C 01.10.18 Added Step 10 and 11 SM  
IPP D 07-10-11 REV C dwg DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

Purchased

No

100

Each

2,212.000

4

16

\*AI S7-1032-130\*

\*\*

Insert

Location

Loc Qty

Loc Code

ST280

127

117717

27

118966

22

119775

78

ST282

2085

119530

73

120181

12

121444

2000

D2208

Manufactured

No

100

Each

1.0000

2

8

\*D2208\*

\*\*

Endcap, Torquemeter

Location

Loc Qty

Loc Code

WA020

1

38144

1

D2207-1

Manufactured

No

180

Each

0.0000

1

4

\*D2207-1\*

\*\*

Housing Body

84087 X4

84088 X8

W 10/2/13

X 16

EL 12-5-20

B 12-6-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

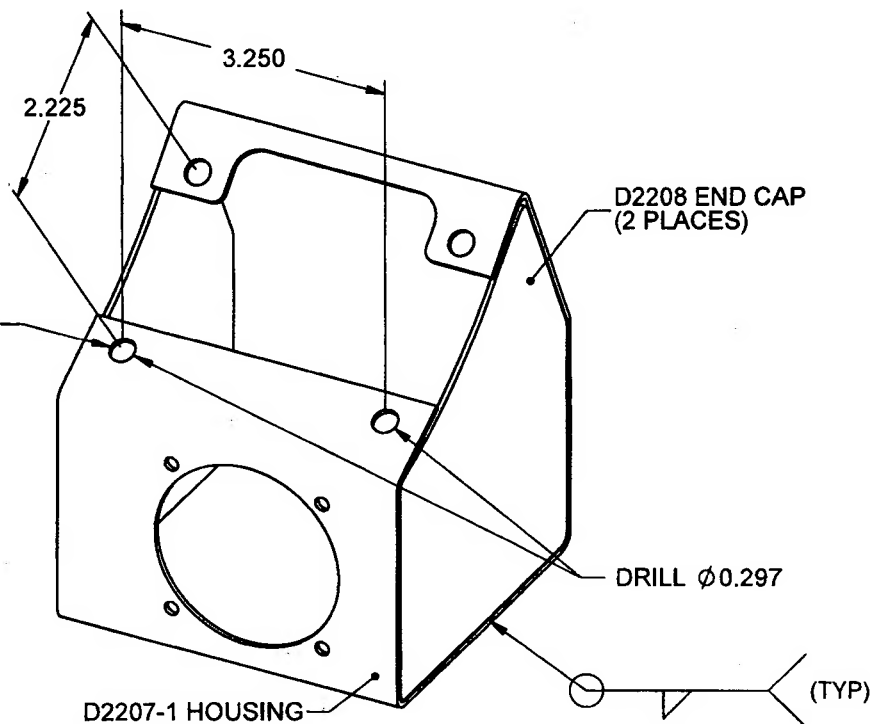
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

AFTER FINISH, INSTALL  
AKS7-1032-130 OR  
ALS7-1032-130 OR  
AKS4-1032-130 OR  
ALS4-1032-130  
(4 PLACES)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84084



RELEASED

07.08.29

*12-05-8*

# **D2207-041 HOUSING ASSEMBLY**

## **NOTES:**

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	<b>D2207</b>	SHEET 1 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	<b>HOUSING</b>	1:2
DATE	<b>07.06.28</b>	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

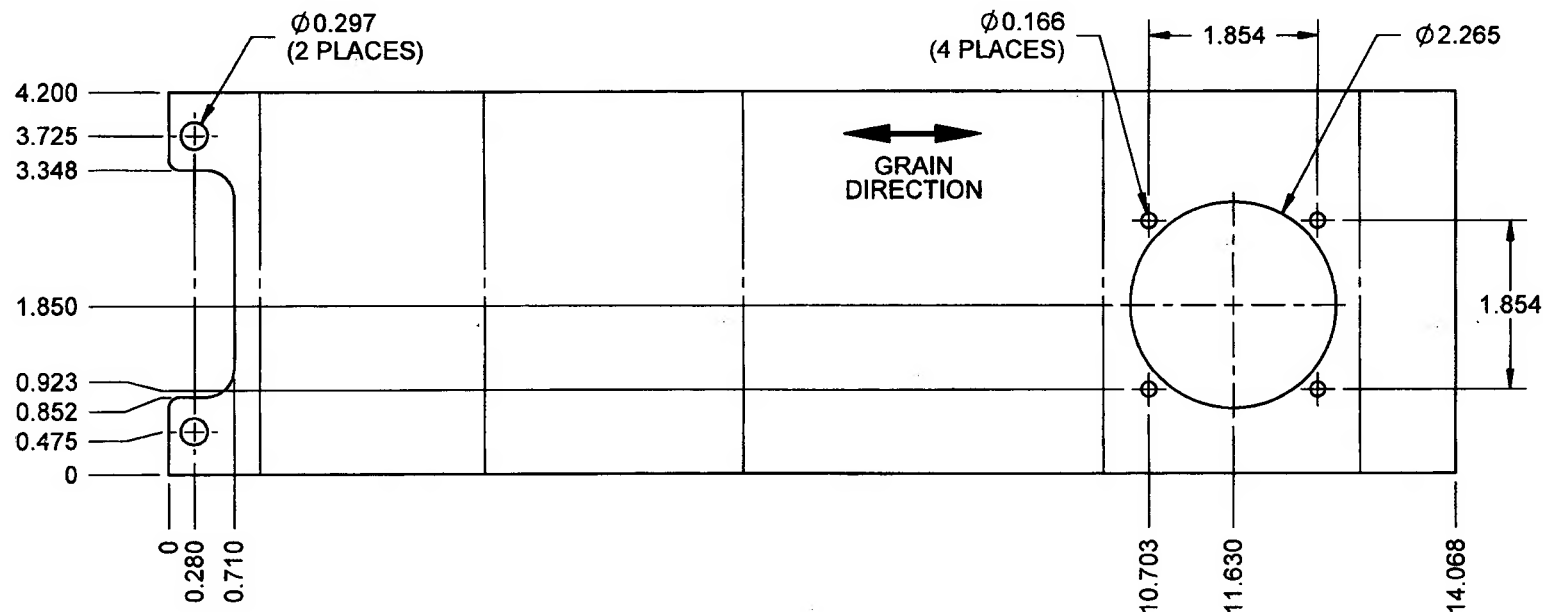
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

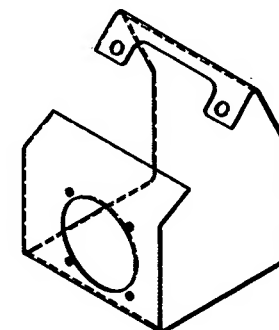
**NOTE:** Date & initial all entries



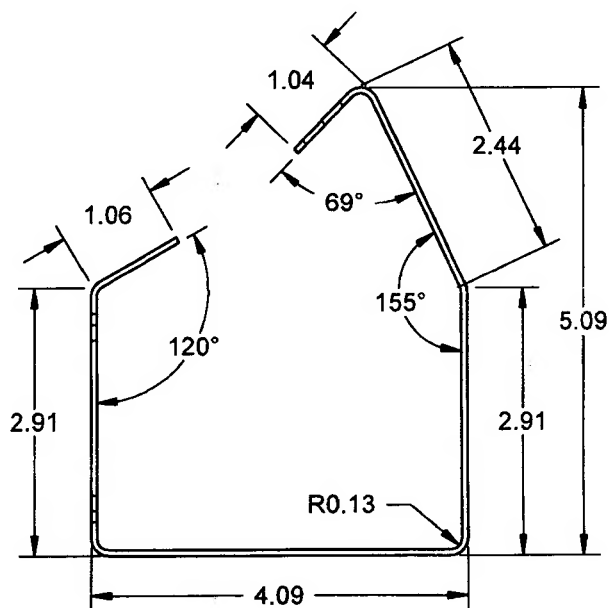
### D2207-1F FLAT PATTERN

#### NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) OR  
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



**ISOMETRIC VIEW**  
(SCALE 1 : 4)



**D2207-1 BENDING DETAIL**

**RELEASED**

07.08.29

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	<b>D2207</b>	SHEET 2 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	<b>HOUSING</b>	1:2
DATE	<b>07.06.28</b>	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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